

Work Order ID 85097

85097

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June-01-12 3:43:31 PM

Item ID: D2672

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw 13" X 24", 206

Stop

NS2

Start Date: 01/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/04

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2672	Rev B1

120 0.00

120

FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

Cut Blank as per File D2672_BLANK

Waterjet B1

89 0 12-06-24

130 0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672
3-Deburr

PO

12/07/05

85 12-07-04 (49)

140 0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

PO

12/07/05

85 12-07-04 (49)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85097

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June-01-12 3:43:31 PM

Item ID: D2672

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw 13" X 24", 206

Start Date: 01/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 15/06/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

150

OK 12/07/09

9

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

0.00

Packaging

Memo

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

OK 12/7/10

QC

Memo

0.00

Quality Control

ME 12-07-10

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-01-12 3:43:35 PM

Page 1

Work Order ID: 85097

85097

Parent Item: D2672

D2672

Parent Item Name: Bearpaw 13" X 24", 206

Start Date: 01/06/2012

Required Date: 15/06/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	253.2100	3.6	28.8			

MUHMWB10

UHMW 1" Black

**

Jun 12-6-24

Location	Loc Qty	Loc Code
MAT018	230.1	
120972	3	
121346	27.1	
121851	200	
MAT019	1.5	
118814	1.5	
ST052	21.60999474	
121277	12.8	
121278	8.80999474	

121954

121954

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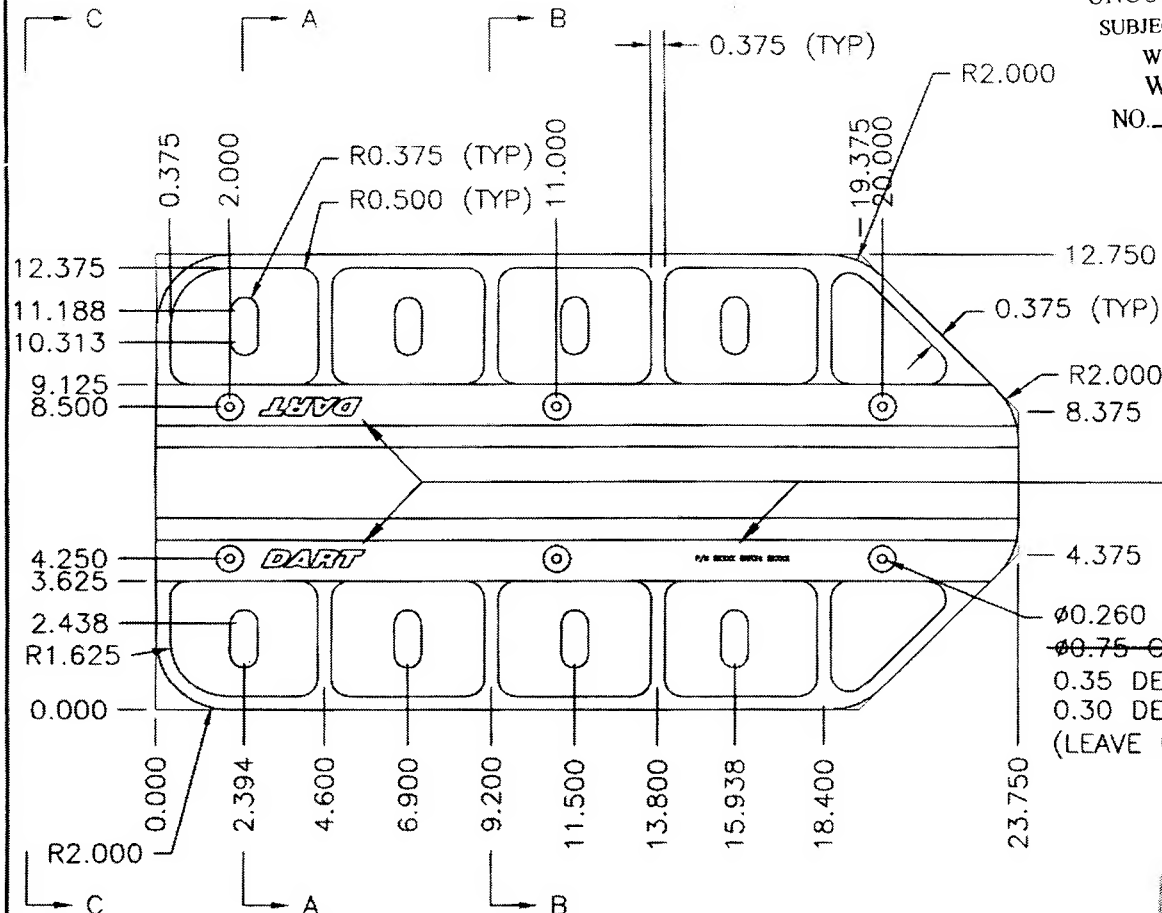
NOTE: Date & initial all entries

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85097 MLJ 12/06/04

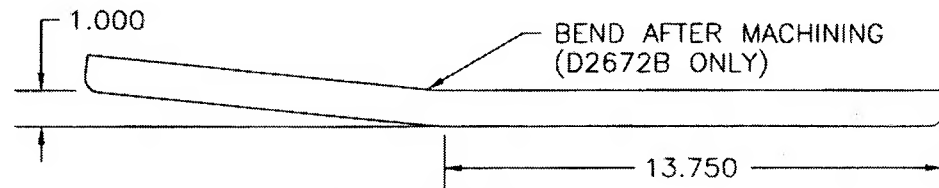
ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)



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FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY		DART AEROSPACE LTD	
KE	KE		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED		DRAWING NO.	
KE	KE		D2672	
DATE	TITLE		REV. B	
98.05.19	BEARPAW		SHEET 1 OF 2	
		SCALE		
		1:5		
A	97.04.08	NEW ISSUE		
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50		
B1	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50		

EFFECTIVE	DEOS
9/14/3	

RELEASED
98.06.17 KE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

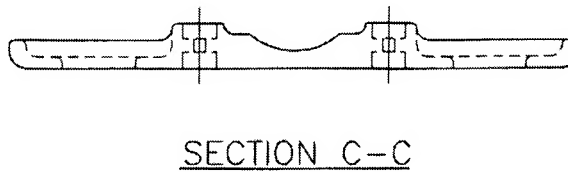
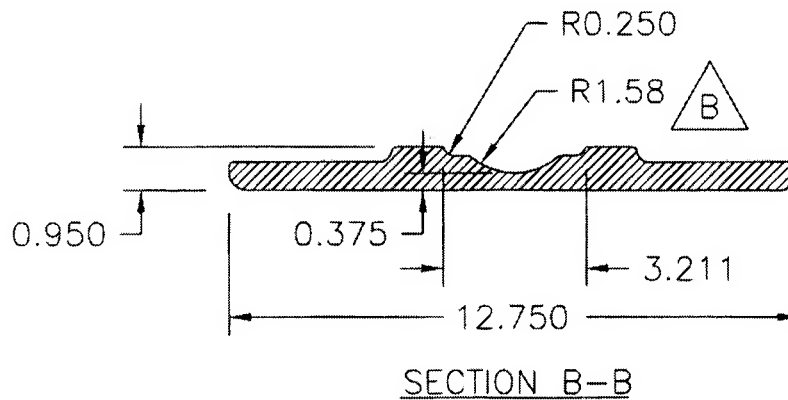
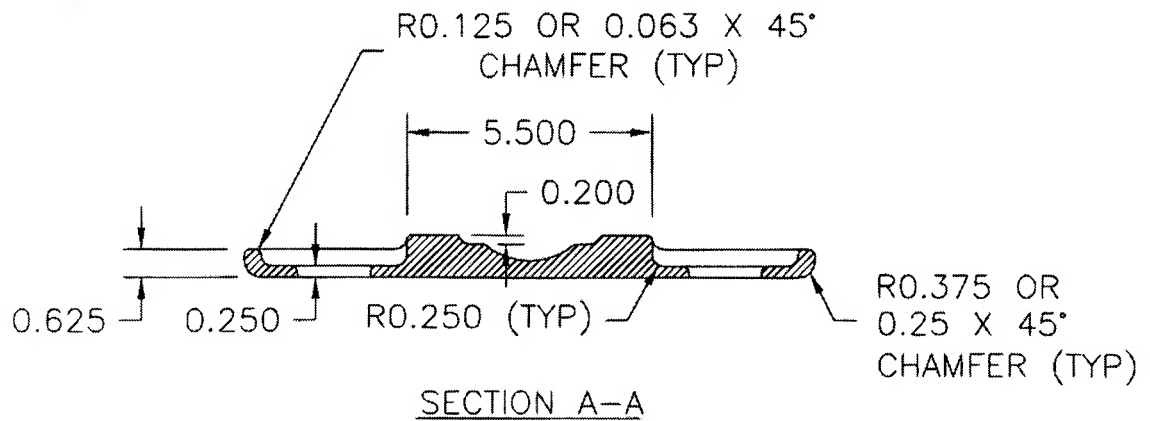
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>WJ</i>	APPROVED <i>SA</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



8509

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 88097
Description: Bearpaw		Part Number: D2672
Inspection Dwg: D2672	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓		Tape	RT-11
B	12.750	+/-0.030	12.750	✓		"	
C	4.250	+/-0.010	4.255	✓		vern	RT-4
D	2.000	+/-0.030	1.993	✓		"	
E	9.000	+/-0.010	9.000	✓		Tape	RT-11
F	0.375	+/-0.030	.379	✓		vern	RT-4
G	9.000	+/-0.010	9.000	✓		Tape	RT-11
H	Ø0.260	+0.005/-0.000	.260	✓		vern	RT-4
I	Ø0.93	+/-0.030	.940	✓		"	
J	0.300	+0.030/-0.000	.301	✓		"	
K	0.625	+/-0.030	.621	✓		"	
L	0.063 x 45°	+0.030/-0.010	.056	✓		"	
M	0.250	+/-0.010	.252	✓		mic	RT-1
N	5.500	+/-0.030	5.504	✓		vern	RT-4
O	R0.250	+/-0.030	.250	✓		rad gauge	
P	0.200	+/-0.030	.191	✓		depth gauge	RT-6
Q	0.25 x 45°	+/-0.030	.249	✓		vern	RT-4
R	0.950	+0.030/-0.010	.956	✓		"	
S	0.375	+/-0.010	.378	✓		"	

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: N/A
Date: 12-07-04	Date: 12/07/04	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF [Signature]	[Signature]